

$$P_{10} \rightarrow$$

W/O: 72669		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/10/14	110	change step to QC 10 -	MS	11.08.17	N/A	N/A	S 11/08/17

Part No: D4417-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72669

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Page 2

Item ID: D4417-041

Accept

Revision ID:

Item Name: Step Assembly

Start Date: 8/4/2011 Start Qty: 1.00

Required Date: 8/8/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 72669

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Item ID:	D4417-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly					
Start Date:	8/4/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/8/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Weld last cap per dwg D4417 & grind flush								
	2-SWAGE TUBES AS PER DWG								
	3-grind flush								
	<i>Red batch # 114703</i>								
160 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11-08-12

Sulostig

Sulostig

EU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72669

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Item ID: D4417-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly

Start Date: 8/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1-Touch up alodine

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1=30
1=320 OF
2=20

M118313

IXD M-11/08/15

190

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

IXD M-11/08/15

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 11 11/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72669

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Item ID:	D4417-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly					
Start Date:	8/4/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/8/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <i>G-A</i>	0.00							
	Packaging								
Packaging	Memo	<i>w/o</i>							
		<i>72668 (1x)</i>							
220	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

8/11/08/16

MF 11-08-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 72669

Parent Item: D4417-041

Parent Item Name: Step Assembly



Start Date: 8/4/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120 *		Manufactured	No			100	Each	0.0000	1	1			
Step Extrusion													
D2734 /		Manufactured	No			100	Each	47.0000	1	1			
Step End Plate													
<div> <div>Location</div> <div>WA</div> <div>70701</div> </div> <div> <div>Loc Qty</div> <div>47</div> <div>47</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2734 /		Manufactured	No			150	Each	47.0000	1	1			
Step End Plate													
<div> <div>Location</div> <div>WA</div> <div>70701</div> </div> <div> <div>Loc Qty</div> <div>47</div> <div>47</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4425-1 /		Manufactured	No			150	Each	0.0000	2	2			
Step Spacer													

Handwritten notes:
 Ae 11.08.11
 WA B68293
 11.08.11
 11.08.12
 11.08.12 B72667

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

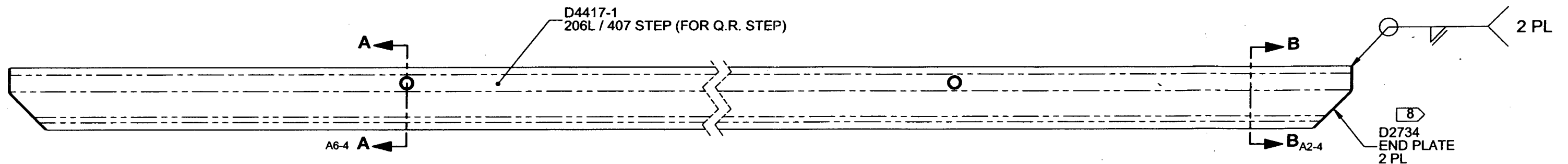
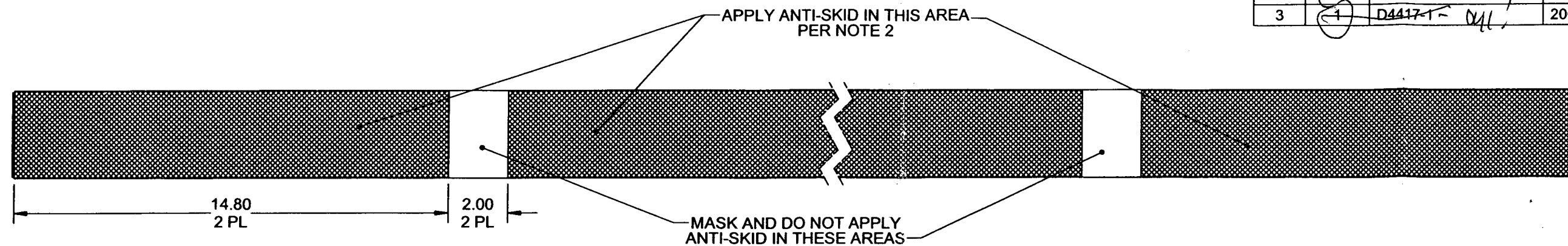
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

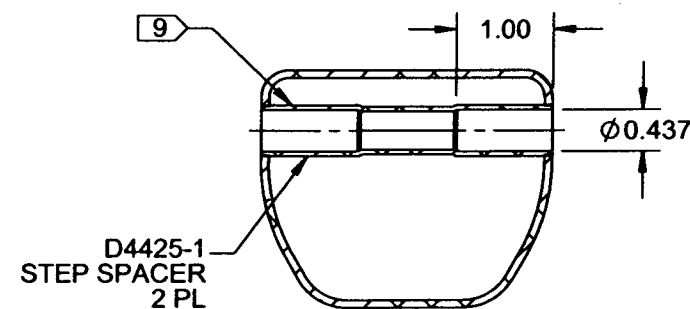
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)

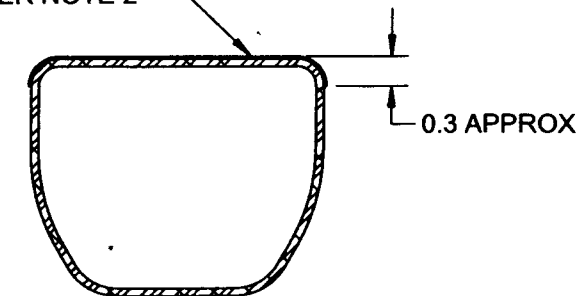


D4417-041 STEP ASSEMBLY



SECTION A-A C7-4 SCALE 2X

APPLY ANTI-SKID IN THIS AREA PER NOTE 2



SECTION B-B C2-4 SCALE 2X

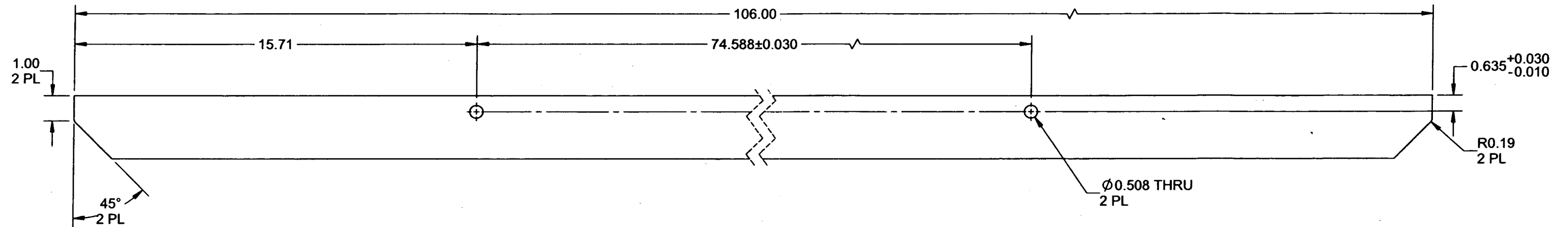
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 8.00 lbs
 - 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
 - 9) SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	NTS
DATE	11.07.28	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-08-02

72669

5.835
254
3481



D4417-1 206L / 407 STEP (FOR Q.R. STEP)

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.77 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4417	REV. B
MFG. APPR.		SHEET 4 OF 4	
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